

Work Order ID 86226

\*86226\*

Page 1

June-25-12 10:29:12 AM

Item ID: D135-751-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube Installation

Start Date: 25/06/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 12/06/25 Tooling:

Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3492

C

D3507

Rev C

100

0.00

\*100\*

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

B86226

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86226

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube Installation

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

**\*120\***

Skidtubes

Skidtubes

0.00

Memo

1-Cut Aft end as per dwg D3507

2-Deburr ends

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

4-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill. \*\*\*\*DO NOT OPEN AFT CAP HOLES\*\*\*\*

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892. Open holes to 0.297"

9-Open Aft & Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Open ground wire hole .297" section E-E

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

*BE 12/08/20*

W/O:		WORK ORDER CHANGES					
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Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube Installation

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
150 <b>*150*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				1	76	12821	
160 <b>*160*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00				1	3	12/08/22	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***

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Revision ID:

Item Name: Skidtube Installation

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Skidtubes	0.00							
<b>*170*</b>									
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"								
	2-Counter Sink X-BOLT holes as per Dwg D3507								
	3-Deburr and blow out chips from inside of tube.								
	4-Bond web as per Dwg D3507 & QSI 015								
	A/R 241 Sike Flex Batch: <u>122443</u>								
	Exp Date: <u>11/03/15</u>								
	start time: <u>7:14</u>								
	end time: <u>12/08/23</u>								
	5-Weld x-bolt (D3504-1/-3)spacers as per Dwg D3507 and Detail C-C & D-D.								
	A/R AL ROD Batch: <u>M122324</u>								
	6-Grind welds flush								
	7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B								
	8-Deburr Rivet hoies.								

-Dec 12/08/22

BE 12/08/23

CF 12.8-24

BB 12/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Skidtube Installation

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 <b>*180*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00				1			
190 <b>*190*</b> Skidtubes Skidtubes	Skidtubes  Memo 1-Rivet D3506-1/-3 as per Dwg D3507.	0.00 0.00				1	0	CF 12-8-24	
200 <b>*200*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				1			

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube Installation

Stop

**\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

Pressure Wash per QSI005 4.3

0.00

**\*210\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 76 12-8-27

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*220\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:30  
3200 F  
9:00

IX 12/08/28

230

QC3- Inspect Part Finish

0.00

**\*230\***

QC

Memo

0.00

Quality Control

IX 12/08/29

W121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube Installation

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	HandFinishing	0.00							
<b>*260*</b>	HandFinish								
Hand Finishing	Memo	0.00							
	<p>1- Install Wearplate &amp; Ground Wire inserts as per Dwg D3507.</p> <p>1-Inspect for Foreign objects</p> <p>2-Install Fwd &amp; Aft caps as per Dwg D3507 And Detail "A" &amp; "B"</p> <p>A/R 241 Sika Flex Batch: <u>11122443</u></p> <p>Exp Date: <u>13103</u></p> <p>3-Install Wearplates as per Dwg D3507 ,</p> <p>Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube</p> <p>Do not Install Scews where indicated on Dwg(Note #6)</p> <p>A/R 241 Sika Flex Batch: <u>11122443</u></p> <p>Exp Date: <u>13103</u></p> <p>4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube</p> <p>A/R 55-o'ring lube batch: <u>11121651</u></p> <p>5- Wing Walk as per Dwg D3507 and QSI 005 4.4</p> <p>Batch: <u>11122320</u></p>								

*1 x 1 p 11 11/08/12*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*86226\***

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June-25-12 10:29:12 AM

Item ID: D135-751-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube Installation

Start Date: 25/06/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270 QC5- Inspect part completeness to step on W/O

0.00

**\*270\***

QC

Memo

0.00

Quality Control

280 Pick Kit

0.00

**\*280\***

Packaging

Memo

0.00

Packaging

290 QC4- 100% Inspect kits for completeness

0.00

**\*290\***

QC

Memo

0.00

Quality Control

*Smf*  
*12-8-30*  
*DAS 16*  
*9-8-1764/30*

*DAS 16*  
*9-3-*  
*12/09/12*

*1*  
*1x*  
*OP*  
*12-8-31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube Installation

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00							
<b>*300*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-751-011								
	Location: _____								
	PPP Rev: <u>B</u>								
310	QC21- Final Inspection - Work Order Release	0.00							
<b>*310*</b>									
QC	Memo	0.00							
Quality Control									

1X \_\_\_\_\_ SP12-9-4

12/9/5 10

MF  
12-09-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

June-25-12 10:29:15 AM

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Work Order ID: 86226

\*86226\*

Parent Item: D135-751-011

\*D135-751-011\*

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A06-06-21New Issue JLM  
 IPP Rev:B 06-12-18 As per Rev B JLM  
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD  
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC vcerified DD  
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F  
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17  
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS7-1032-130

Purchased

No

Each

1,998.000

38

\*AI S7-1032-130\*

Insert

\*\*

41 12/08/29

## Location

## Loc Qty

## Loc Code

ST280

51

117717

27

118966

22

119775

2

ST282

1947

119530

73

120181

12

121444

1862

11122474

x38

D3507-1-BENT

Manufactured

No

120

Each

4.0000

1

1

\*D3507-1-BENT\*

Skidtube Assembly EC135

\*\*

BE 06/08/20  
 B88713 2/

## Location

## Loc Qty

## Loc Code

LG

4

77441

1

83177

2

83303

1

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Work Order ID: 86226

**\*86226\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3504-1 Manufactured No

170 Each 24.0000 2 2

**\*D3504-1\***

Crossbolt Spacer

\*\*

BE 12/08/23

Location	Loc Qty	Loc Code
LG	3	
82725	3	2
LG001	21	
53742	2	
75240	19	

D3504-3 Manufactured No

170 Each 24.0000 1 1

**\*D3504-3\***

Crossbolt Spacer

\*\*

BE 12/08/23

Location	Loc Qty	Loc Code
LG	13	
82726	13	1
LG001	11	
53743	11	

D3504-5 Manufactured No

170 Each 17.0000 2 2

**\*D3504-5\***

Crossbolt Spacer

\*\*

BE 12/08/23

Location	Loc Qty	Loc Code
LG001	17	
76239	5	2
82727	12	

D3505-1 Manufactured No

170 Each 2.0000 1 1

**\*D3505-1\***

Web

\*\*

DE 12/08/22

Location	Loc Qty	Loc Code
LG001	2	0
75211	1	
83547	1	

June-25-12 10:29:16 AM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 3

Work Order ID: 86226

\*86226\*

Parent Item: D135-751-011

\*D135-751-011\*

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3506-1 Manufactured No

190 Each

23.0000

4 4

\*D3506-1\*

Doubler

\*\*

CF 12.8.24

## Location

## Loc Qty

## Loc Code

ST051

23

75090

23

(4)

D3506-3 Manufactured No

190 Each

47.0000

2 2

\*D3506-3\*

Doubler

\*\*

CF 12.8.24

## Location

## Loc Qty

## Loc Code

ST051

47

51790

47

(2)

MS20601-AD4W3 Purchased No

190 Each

1,767.000

12 12

\*MS20601-AD4W3\*

Rivet

\*\*

CF 12.8.24

## Location

## Loc Qty

## Loc Code

ST321

1767

114538

1767

(12)

ALS4-1032-225 Purchased No

260 Each

493.0000

1 1

\*ALS4-1032-225\*

Insert

\*\*

11108129

## Location

## Loc Qty

## Loc Code

ST281

470

108696

146

110768

62

118386

55

118966

68

121269

139

ST282

23

120410

10

120451

13

11122290

x1

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# Picklist Print

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Work Order ID: 86226

**\*86226\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

260

Each

4,859.000

31

31

**\*AN3C4A\***

BOLT

\*\*

21 12/08/29

Location

Loc Qty

Loc Code

ST350

4859

120187

31

120521

28

120769

38

121205

754

121556

8

122151

4000

X31

AN3C5A

Purchased

No

260

Each

1,688.000

2

2

**\*AN3C5A\***

Bolt

\*\*

21 12/08/29

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1681

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121068

12

121255

500

121444

68

121708

500

122141

500

X2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 5

Work Order ID: 86226

\*86226\*

Parent Item: D135-751-011

\*D135-751-011\*

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN526C1032R10

Purchased

No

260

Each

189.0000

2

2

\*AN526C1032R10\*

Screw

\*\*

11 12/08/29

Location

Loc Qty

Loc Code

FP002

69

108062

69

Y2

ST348

120

110049

20

114494

100

AN960C10L

NAS1149C0332

Purchased

No

260

Each

21.0000

33

33

\*AN960C10L \* \*

washer

11 12/06/3 \*\*

(x33) 11 12/08/29

Location

Loc Qty

Loc Code

ST

21

107534

21

D2965

Manufactured

No

260

Each

44.0000

1

1

\*D2965\*

Cap, 105 Skidtube

\*\*

11 12/08/29

Location

Loc Qty

Loc Code

FP002

44

71371

4

Y1

80089

40

D2965-3

Manufactured

No

260

Each

11.0000

1

1

\*D2965-3\*

Cap

\*\*

11 12/08/29

Location

Loc Qty

Loc Code

FP002

11

50560

1

75254

3

Y1

84051

7

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 6

Work Order ID: 86226

\*86226\*

Parent Item: D135-751-011

\*D135-751-011\*

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-1 Manufactured No

260 Each

205.0000 4 4

\*D3492-1\*

Plug

\*\*

u 12/08/29

## Location

## Loc Qty

## Loc Code

FP002

198

69531

8

B87662

u

74444

2

76235

4

83259

184

FP-A

7

83098

7

D3492-3 Manufactured No

260 Each

139.0000 4 4

\*D3492-3\*

Plug

\*\*

u 12/08/29

## Location

## Loc Qty

## Loc Code

FP-A

139

81967

5

B85461

u

83099

12

83529

122

D3492-7 Manufactured No

260 Each

22.0000 2 2

\*D3492-7\*

Plug

\*\*

u 12/08/29

## Location

## Loc Qty

## Loc Code

FP002

22

71881

2

77222

20

u

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 86226

\*86226\*

Parent Item: D135-751-011

\*D135-751-011\*

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3508-1	Manufactured	No	260	Each	6.0000	1	1
<b>*D3508-1*</b>						**	HL 12/08/29
Wearplate							

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP	6	
	85407	6	VI
D3508-3	Manufactured	No	260
<b>*D3508-3*</b>			Each 7.0000
Wearplate			** HL 12/08/29

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP001	7	
	38527	1	
	81347	6	VI
D3508-5	Manufactured	No	260
<b>*D3508-5*</b>			Each 10.0000
Wearplate			** HL 12/08/29

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP001	10	
	71688	2	
	72416	8	VI
D3508-7	Manufactured	No	260
<b>*D3508-7*</b>			Each 7.0000
Wearplate			** HL 12/08/29

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP001	7	
	76265	7	388207 XI

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 86226

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

\*86226\*

\*D135-751-011\*

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3558-1	Manufactured	No	260	Each	37.0000	1	1
<b>*D3558-1*</b>						**	<u>u</u> 11/08/29
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	37	
50925	1	
73561	3	
<u>84090</u>	33	<u>yl</u>

D3558-3	Manufactured	No	260	Each	7.0000	1	1
<b>*D3558-3*</b>						**	<u>u</u> 11/08/29
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	6	
<u>82312</u>	6	<u>yl</u>
FP002	1	
71651	1	

D3558-5	Manufactured	No	260	Each	6.0000	1	1
<b>*D3558-5*</b>						**	<u>u</u> 11/08/29
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	6	
<u>75255</u>	6	<u>yl</u>

D3558-7	Manufactured	No	260	Each	4.0000	1	1
<b>*D3558-7*</b>						**	<u>u</u> 11/08/29
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	4	
75249	4	1386037 <u>yl</u>

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 86226

**\*86226\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-007

Purchased

No

260

Each

254.0000

2

2

**\*NAS1611-007\***

O-RING

\*\*

*u u/08/25*

Location

Loc Qty

Loc Code

FP001

254

103697

254

*x 2*

NAS1611-010

Purchased

No

260

Each

416.0000

4

4

**\*NAS1611-010\***

O-RING

\*\*

*u u/08/29*

Location

Loc Qty

Loc Code

FP001

416

110915

14

117460

8

118077

1

118612

3

119438

47

121259

2

121584

2

121723

39

122151

300

*x 4*

NAS1611-013

Purchased

No

260

Each

317.0000

4

4

**\*NAS1611-013\***

O-RING

\*\*

*u u/08/29*

Location

Loc Qty

Loc Code

FP001

317

116582

5

117291

2

117887

53

119623

36

121584

5

121825

174

*x 4*

121826

42

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 86226

\*86226\*

Parent Item: D135-751-011

\*D135-751-011\*

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

280

Each

4,859.000

8

8

\*AN3C4A\*

BOLT

\*\*

M122814

Location

Loc Qty

Loc Code

ST350

4859

120187

31

120521

28

120769

38

121205

754

121556

8

122151

4000

AN960C10L

NAS1149C0332

Purchased

No

280

Each

21.0000

8

8

\*AN960C10I \*

washer

\*\*

M122063. SP

Location

Loc Qty

Loc Code

ST

21

107534

21

D3512-1

Manufactured

No

280

Each

21.0000

2

2

\*D3512-1\*

Wearplate

\*\*

SP 12-8-31

Location

Loc Qty

Loc Code

ST500

1

74735

1

ST501

20

81352

2

83343

18

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86226 MJS  
12/06/25

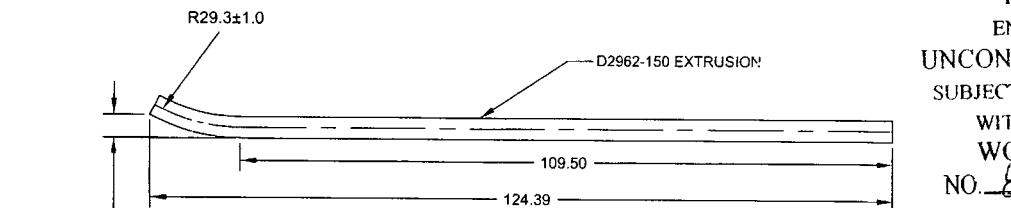
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

#### GENERAL NOTES:

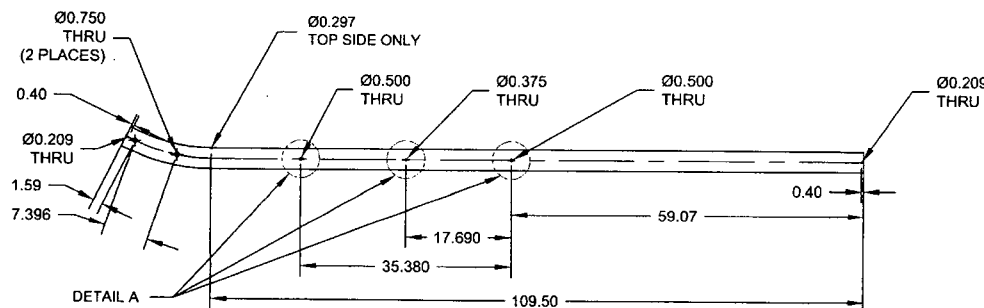
- 1) FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	JFC		
CHECKED	RA		
MFG. APPR.	EC		
APPROVED			
DE APPR.			
DATE	07.09.19		
<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA DRAWING NO. D3507 TITLE EC 135 SKIDTUBE SCALE NTS COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

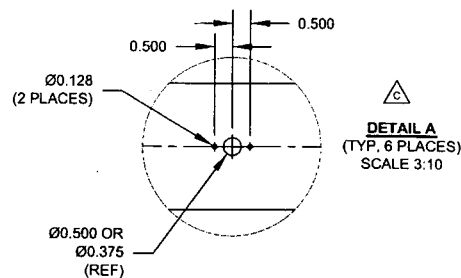
RELEASED  
07.11.16



**D3507-1 BENDING/CUTTING DETAIL**



**D3507-1 DRILLING DETAIL**



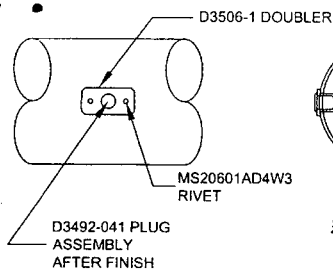
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

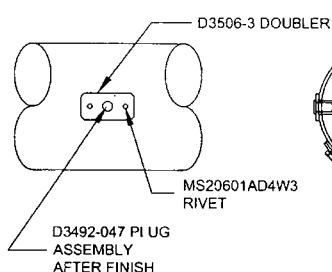
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**SECTION C-C**  
(SCALE 3:10)

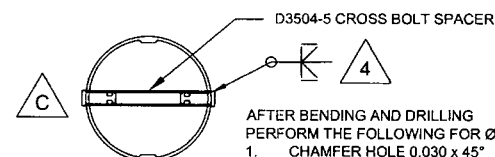
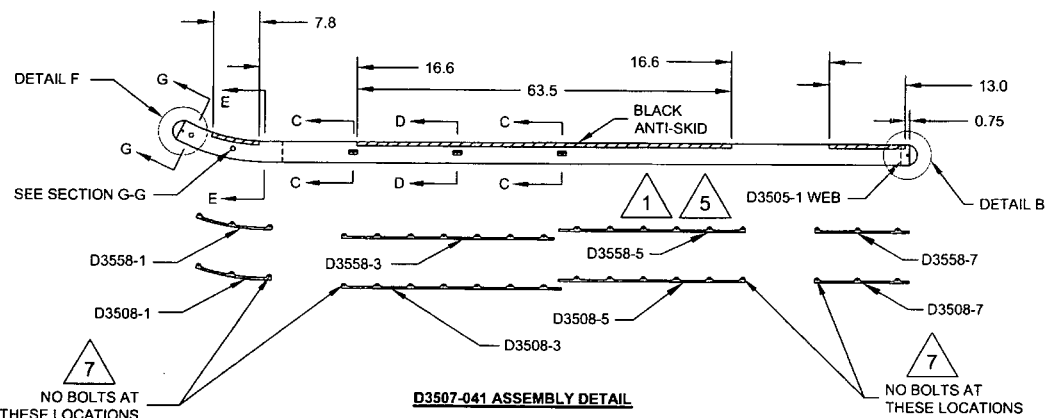
- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-1 CROSS BOLT SPACER (2 PLACES)
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.404 (1/8" DRILL) THRU HOLE
  5. INSTALL D3506-1 DOUBLER (4 PLACES) USING MS20601AD4W3 RIVET (8 PLACES)
  6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY (4 PLACES)



**SECTION D-D**  
(SCALE 3:10)

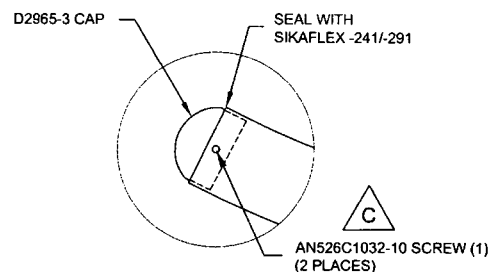
- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-3 CROSS BOLT SPACER (1 PLACES)
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.277 (1/8" DRILL) THRU HOLE
  5. INSTALL D3506-3 DOUBLER (2 PLACES) USING MS20601AD4W3 RIVET (4 PLACES)
  6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY (2 PLACES)

06226

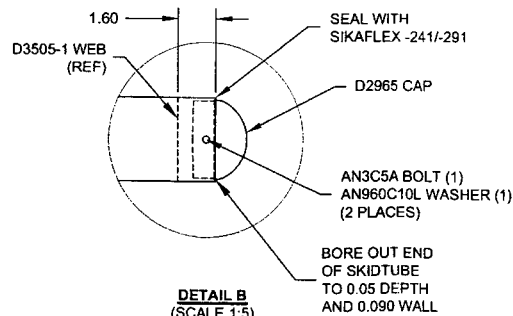


**SECTION G-G**  
(SCALE 3:10)

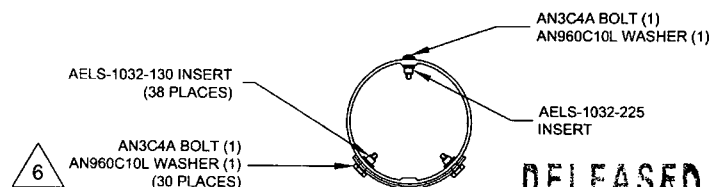
- AFTER BENDING AND DRILLING PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
  2. INSERT D3504-5 CROSS BOLT SPACER (2 PLACES)
  3. WELD INTO PLACE AND GRIND FLUSH
  4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
  5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY (4 PLACES)



**DETAIL F**  
(SCALE 1:5)



**DETAIL B**  
(SCALE 1:5)



**SECTION E-E**  
(SCALE 3:10)

RELEASED  
07-11-18

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	BA	DRAWING NO.	REV. C
MFG. APPR.	CE	D3507	SHEET 2 OF 2
APPROVED	WFO	TITLE	SCALE
DE APPR.	WFO	EC 135 SKIDTUBE	1:20
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 247

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 66661  
Part number: D135-751-011  
Description: 135 SKID tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Jones Date of Test Coupon 11/03/17  
Welder Barclay Elliot Date of Test Coupon 11/03/17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld